

Work Order ID 133735

Tuesday, June 16, 2015 11:04:54 AM

133735

Page 1

Item ID: PB67-43001-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Blade Support And Cover Assembly
 Start Date: 6/16/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 6/16/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUN 17 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-23	Rev C								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg PB67-43001								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Identify as per dwg & Stock Location: <u>W/A</u>								
Packaging	Memo	0.00							
Packaging									

GA 10/28/12 DAS 36 9-89

(6) AUG 13 DAS 38 9-89

MR-15-8-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 133735

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133735

Page 2

Item ID: PB67-43001-23

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Blade Support And Cover Assembly

Start Date: 6/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ

AUG 17 2015

MF
15-8-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Tuesday, June 16, 2015 11:04:57 AM

Page 1

Work Order ID: 133735

133735

Parent Item: PB67-43001-23

PB67-43001-23

Parent Item Name: Lower Blade Support And Cover Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-10		Purchased	No			100	Each	362.0000	8	48			DAS
MS27039-1-10									**			15/08/12	36
SCREW													9-89

Location	Loc Qty	Loc Code
CA	41	
m128635	41	
GA	239	
m129541	239	
ST285	82	
m123522	2	
m130358	70	
m130388	10	

NAS1149D0316J

Purchased

No

100

Each

345.0000

8

48

NAS1149D0316.J

Washer

Location	Loc Qty	Loc Code
GA	132	
122151	132	
ST270	213	
M127956	213	

15/08/12

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
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OTHER : ☐					

Picklist Print

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Page 2

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133735

Parent Item: PB67-43001-23

PB67-43001-23

Parent Item Name: Lower Blade Support And Cover Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0363J

Purchased

No

100

Each

1,765.000

12

72

NAS1149D0363.J

Washer

DAS
36
9-89
15/08/12

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

182

m128429

182

ST269

1014

m126319

7

m131618

7

m132317

1000

M132677
72x

PB67-43001-181

Manufactured

No

100

Each

11.0000

1

6

PB67-43001-181

Cover Plate

Location

Loc Qty

Loc Code

Mezz2

11

111815

11

100

Each

0.0000

1

6

PB67-43001-79

Manufactured

No

PB67-43001-79

Lower Blade Support Assembly

B133737 (6x) **

MF 15-7-17

PB67-43001-83

Manufactured

No

100

Each

24.0000

1

6

PB67-43001-83

D-Pad Assembly, Short

Location

Loc Qty

Loc Code

Mezz2

24

111757

24

MF 15-7-17

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Shop Packet Print

Page 2

DQA: _____ Date: _____

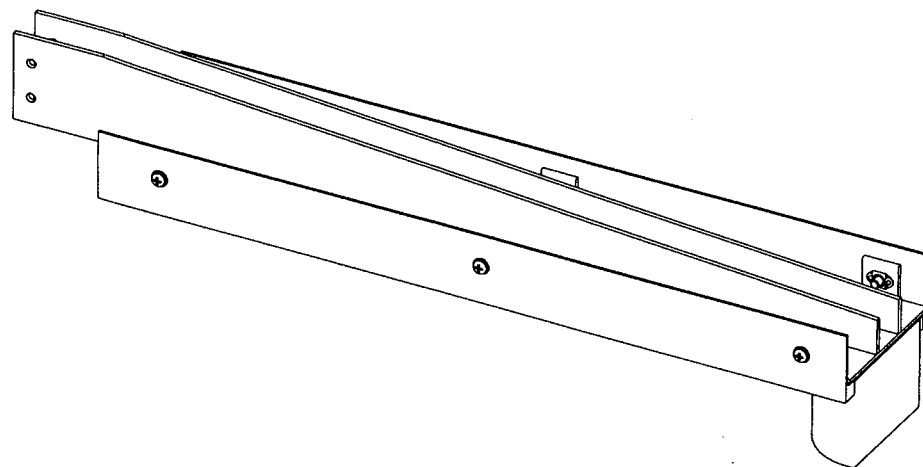


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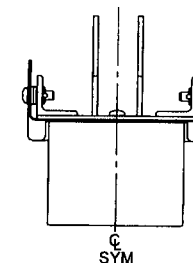
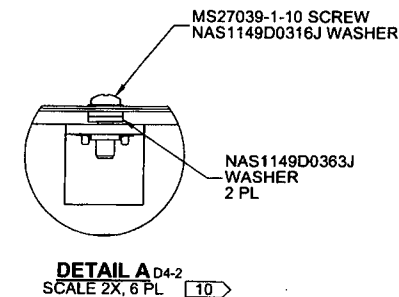
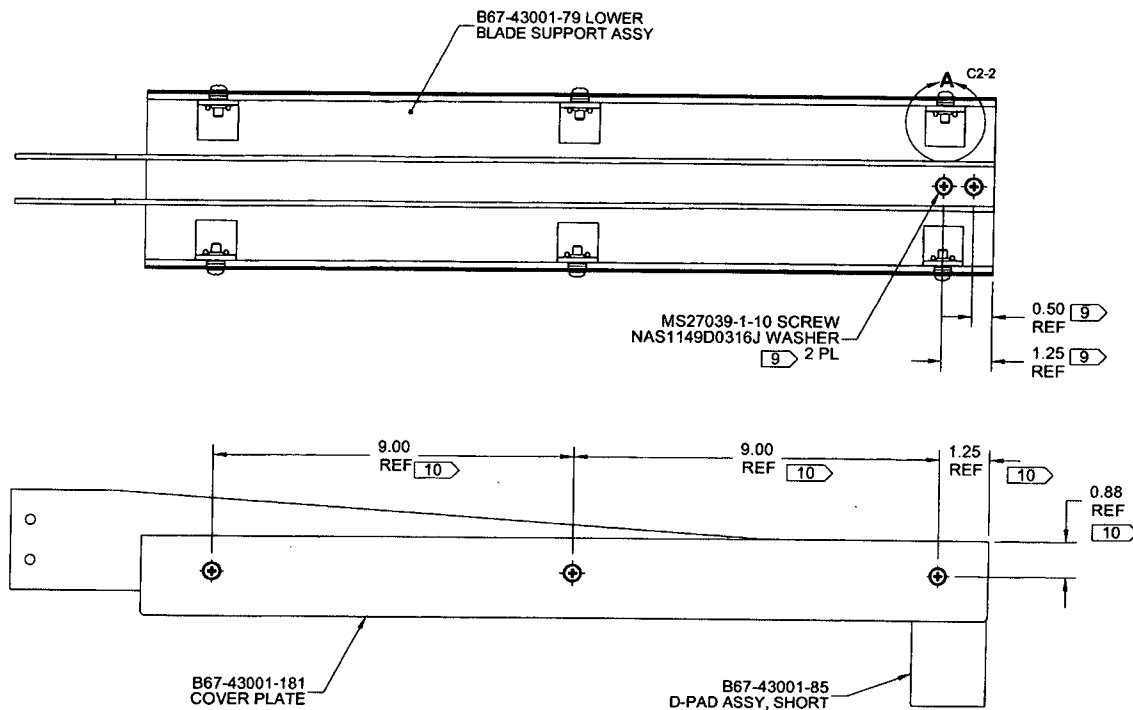
B67-43001-23 LOWER BLADE SUPPORT AND COVER ASSY

ITEM	QTY -23	P/N	DESCRIPTION
1	X	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
3	1	B67-43001-79	LOWER BLADE SUPPORT ASSY
4	1	B67-43001-83	D-PAD ASSEMBLY, SHORT
5	1	B67-43001-181	COVER PLATE
7	8	MS27039-1-10	SCREW
8	8	NAS1149D0316J	WASHER
9	12	NAS1149D0363J	WASHER

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 2010-09-16
 MB

C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 10 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.07.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-23 REV. C SHEET 1 OF 2 TITLE LOWER BLADE SUPPORT AND COVER ASSY NTS SCALE DATE 09.07.28 COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN	JS			
CHECKED	JS			
MFG. APPR.	JS			
APPROVED	JS			
DE APPR.	N/A			



B67-43001-23 LOWER BLADE SUPPORT AND COVER ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.10 lbs
- 8) WELDING: PER DART QSI 004
- 9) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-181 WITH HOLE PATTERN OF B67-43001-79
- 10) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-181 WITH HOLES IN ANGLE BRACKETS ON B67-43001-79

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-23	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT AND COVER ASSY	NTS
DATE	09.07.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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